

Work Order ID 65900

Thursday, January 27, 2011 7:41:56 AM

Page 1

Item ID: D3183-9

Accept

Setup Start

Revision ID:

Stop

Item Name: Cap

Start Date: 1/27/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 1/27/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3183

Rev C1

100

0.00

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn D3183-9 Cap as per Folio FA3881 Debur

110

0.00

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

# Work Order ID 65900

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Item ID: D3183-9

Accept

Setup Start

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Stop

Item Name: Cap

Start Date: 1/27/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 1/27/2011 Req'd Qty: 20.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: 236

0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/01/27  
11/01/27

# Picklist Print

Thursday, January 27, 2011 7:41:54 AM

Page 1

Work Order ID: 65900

Parent Item: D3183-9

Parent Item Name: Cap

Start Date: 1/27/2011

Required Date: 1/27/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 06.05.03 New issue KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELINR1.000		Purchased	No			100	f	22.4250	0.0333	0.701053			

Delrin Round Bar 1"

Location

Loc Qty

Loc Code

MAT

22.425

116266

22.425

SA 11/12/7

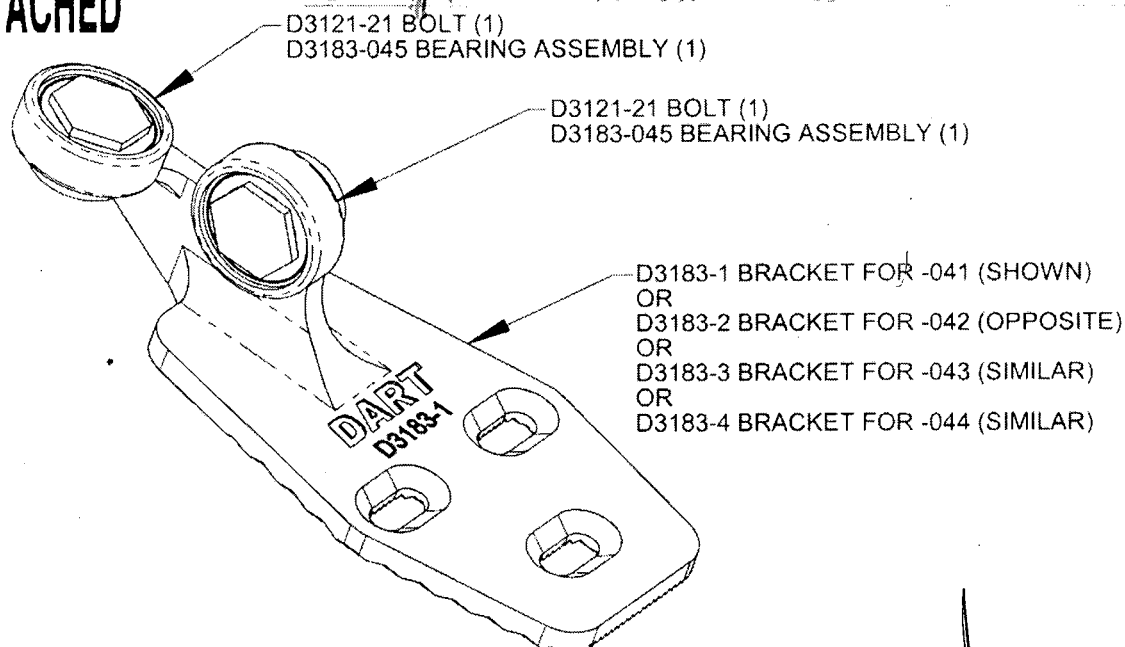
821





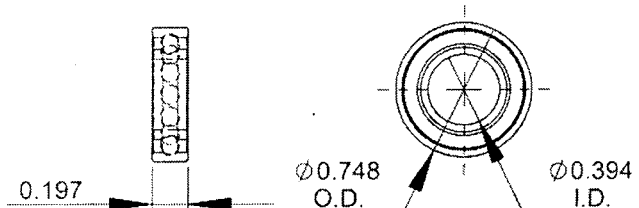
DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3183</b>	REV. C SHEET 1 OF 4
DATE <b>04.02.17</b>	TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1	
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	

RELEASED  
04 03 01  
DEO ATTACHED



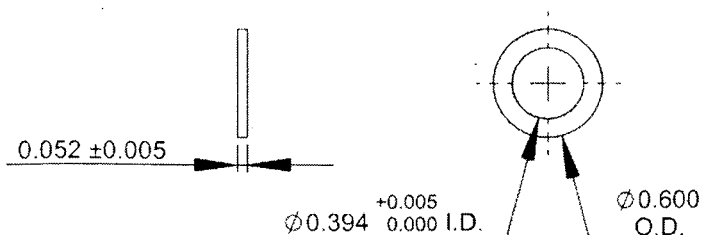
**D3183-041 BRACKET ASSEMBLY (SHOWN)**  
**D3183-042 BRACKET ASSEMBLY (OPPOSITE)**  
**D3183-043 BRACKET ASSEMBLY (SIMILAR)**  
**D3183-044 BRACKET ASSEMBLY (SIMILAR)**

*Wb/5900*



**D3183-5 BEARING:**  
**SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



**D3183-7 WASHER**

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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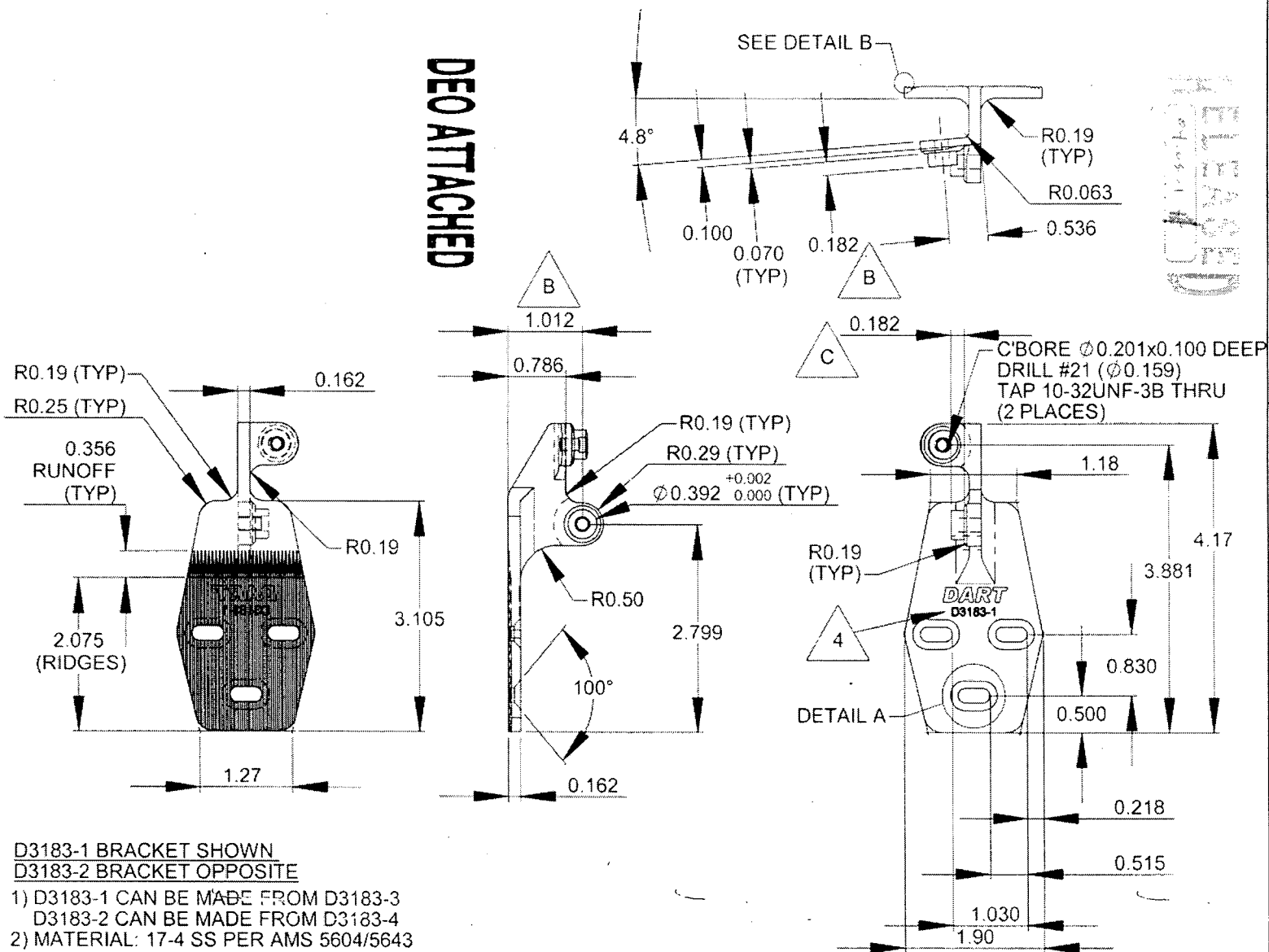
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**DART**



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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. C
04.02.17	D3183	SHEET 2 OF 4
	BRACKET ASSEMBLY	SCALE 1:2






**DEO ATTACHED**

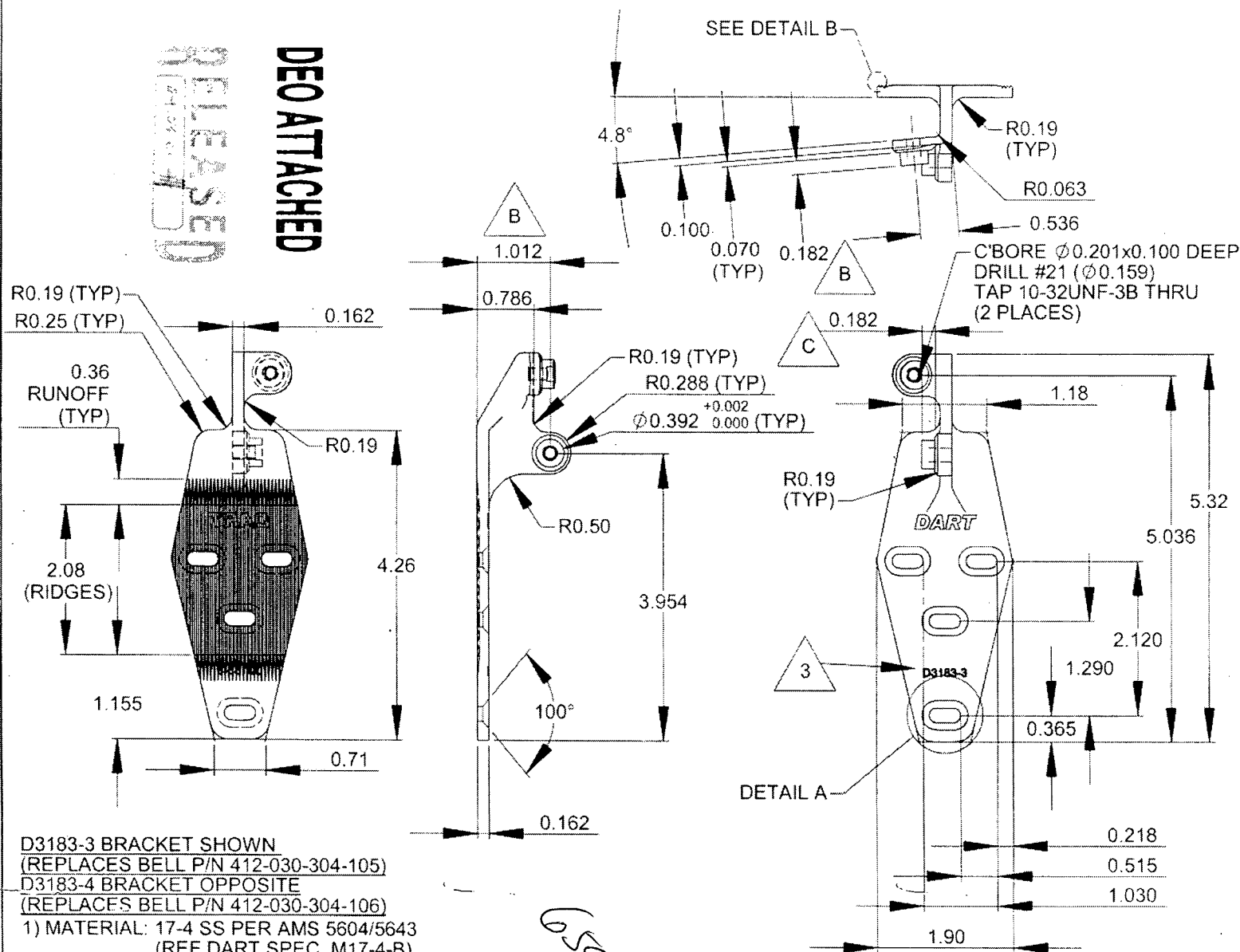


**D3183-1 BRACKET SHOWN  
D3183-2 BRACKET OPPOSITE**

- 1) D3183-1 CAN BE MADE FROM D3183-3  
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

*165902*

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CHECKED 	APPROVED 	REV. C 
DATE 04.02.17		SHEET 3 OF 4
TITLE BRACKET ASSEMBLY		SCALE 1:2



D3183-3 BRACKET SHOWN  
(REPLACES BELL P/N 412-030-304-105)  
D3183-4 BRACKET OPPOSITE  
(REPLACES BELL P/N 412-030-304-106)

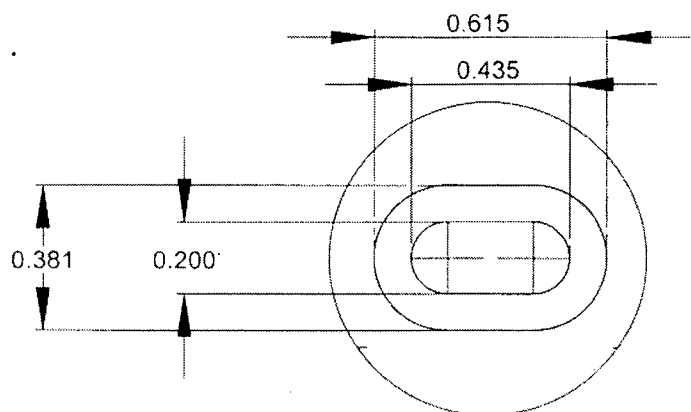
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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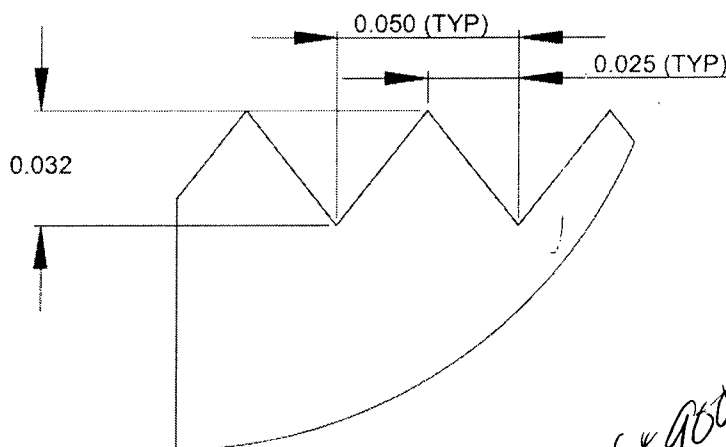
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3183</b>	REV. C SHEET 4 OF 4
DATE <b>04.02.17</b>	TITLE <b>BRACKET ASSEMBLY</b>		SCALE 1:1



DETAIL A (2 : 1)

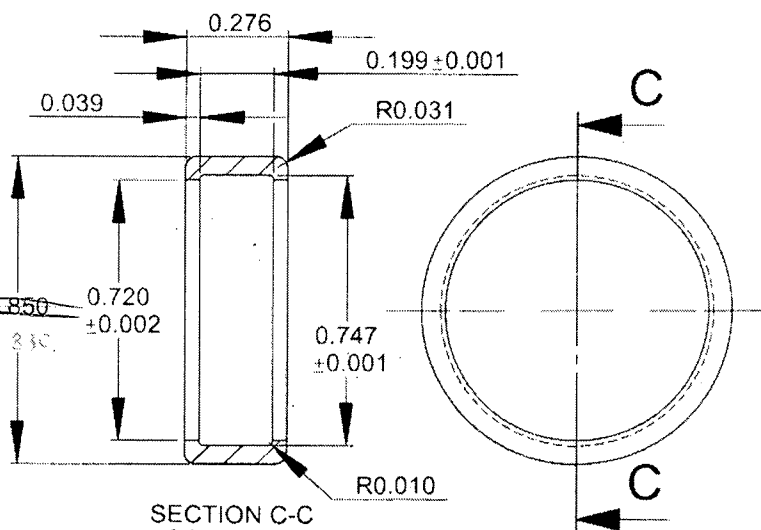
RELEASED  
04 03 2017

DEO ATTACHED



DETAIL B (20 : 1)

65900



SECTION C-C  
SCALE 2 : 1

**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP

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DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV.C1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3183-C1-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>MP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30		DATE 10/06/30		

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]  
Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

**RELEASED**  
2010-07-22  
*MP*

*65000*